







rDate: Monday, 7/16/2007 2:48:17 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LUG BRACKET
Job Number : 33569	
Estimate Number : 10010	
P.O. Number : <i>N/A</i>	Part Number : D27353
This Issue : 7/16/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2735 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 33091	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 7/30/2007 Qty: 30 Um: Each
Checked & Approved By : <i>[Signature]</i> 07.07.17	
Comment : Est Rev: C Removed from 9 Digit 05-10-25 JLM Est. C 06.07.21 waterjet EC	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation: Description :
1.0	M1010S125 1010-1025 sheet .125
	
Comment: Qty.: 0.1733 sf(s)/Unit Total : 5.1975 sf(s) <i>IB 07-07-22</i> 1010-1025 sheet .125 batch: <i>M10343310 m104699 ✓ -2</i>	
2.0	WATER JET FLOW WATER JET
	
Comment: FLOW WATER JET 1-Cut as per Dwg D2735 <i>IB 07-07-22</i> Dwg Rev: <i>C</i> Prog Rev: <i>C</i> 2-Deburr if necessary <i>(35)</i>	
3.0	QC2 INSPECT PARTS, AS THEY COME OFF MACHINE
	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>IB 07-07-22</i>	
4.0	QC8 SECOND CHECK
	
Comment: SECOND CHECK <i>EP 07/07/23</i> <i>(35)</i> <i>comp</i>	
5.0	BRAKE NC NC BRAKE
	
Comment: NC BRAKE 1-Form D2735-1 as per Dwg D2735. Use CNC Brake Jig DT8204 2-Deburr if required. <i>SB 07/10/03</i> <i>16</i> <i>07/07/24</i> <i>(35)</i>	

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Drawing Name: LUG BRACKET

Job Number: 33569

Part Number: D27353

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



counter

Comment: INSPECT WORK TO CURRENT STEP

Er 07/10/25 (+16)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: RAT-D.

10

07/10/26

AS

(16x)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/10/26

Job Completion



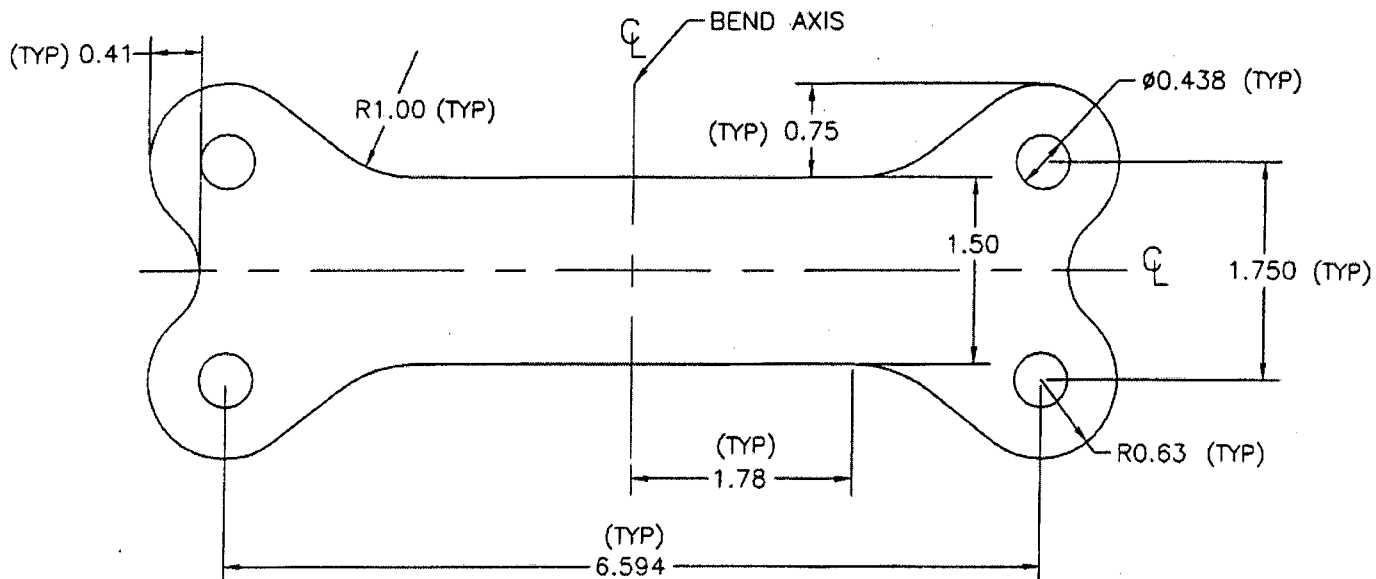
U 07/10/26



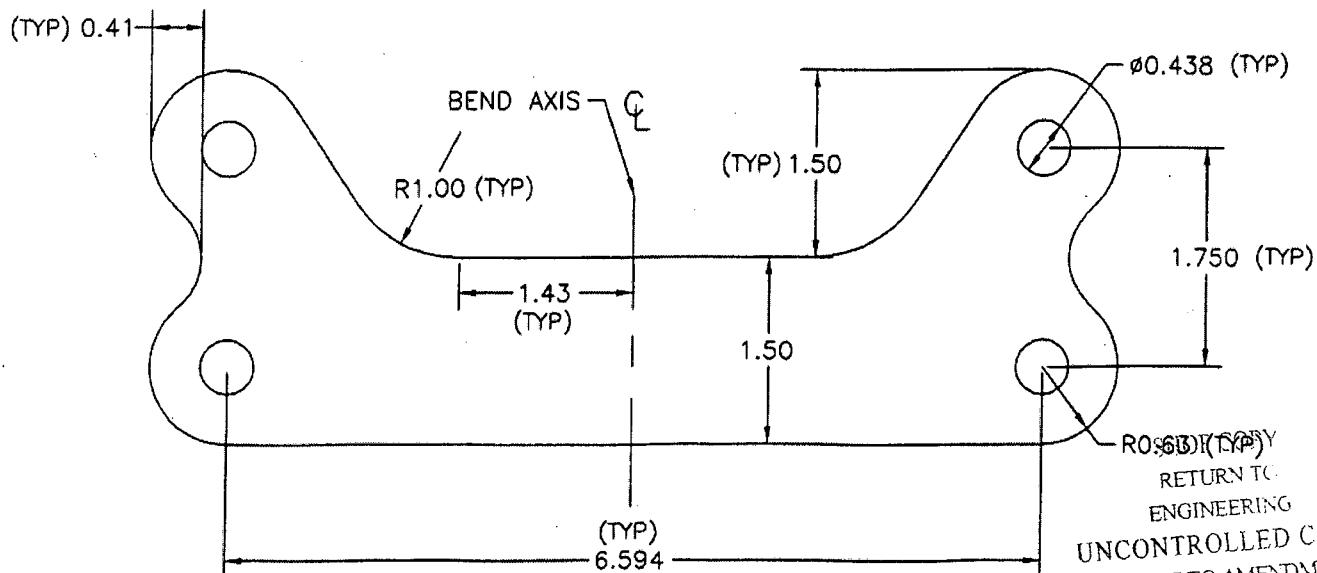


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2735	REV. C SHEET 1 OF 2
DATE 98.12.14		TITLE LUG BRACKET	SCALE 2:3
A	97.12.14	NEW ISSUE	
B	98.10.23	UPDATE MATERIAL (TSR A1114)	
C	98.12.14	REMOVE TOOLING HOLES (TSR A1040)	

RELEASED  
98.12.14 DS



D2735-1 FLAT PATTERN  
SYMMETRIC ABOUT BOTH CENTRE-LINES (CL)



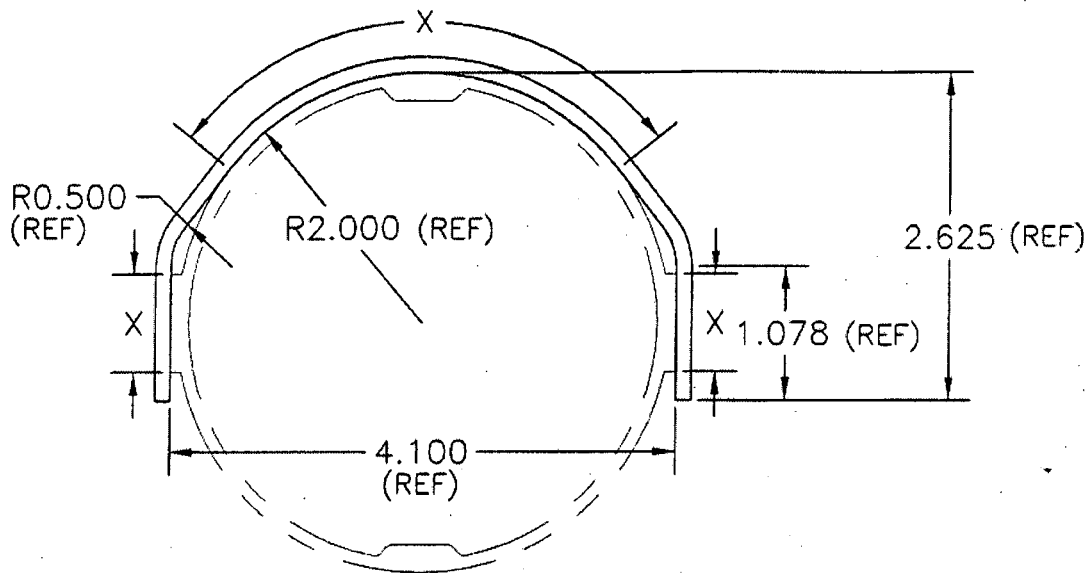
D2735-3 FLAT PATTERN  
SYMMETRIC ABOUT CENTRE-LINE (CL)

NO. 33569  
WORK ORDER  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>KE</i>	DRAWING NO. D2735	REV. C SHEET 2 OF 2
DATE 98.12.14		TITLE LUG BRACKET	SCALE 2:3

RELEASED  
98.12.14 DS



D2735-1 AND D2735-3 BEND DETAIL

D2735-1 AND D2735-3 SHOULD BE BENT TO WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2500-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL  
0.125 THICK (11 GAUGE)  
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi  
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 33569

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2735-3 PAR #: N/A Fault Category: Prod / Process <sup>media small</sup> NCR: Yes No DQA: D Date: 01/10/04  
 QA: N/C Closed: H Date: 07.10.29

NCR: <u>33569</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>7/10/01</u>	<u>1</u>	<u>Wrong material were pull use 4'130 instead 1010 19 piece were scrap</u>	<u>[Signature]</u> <u>05/10/02</u>	<u>Scrap + destroy</u> <u><del>replace</del> No replace</u> <u>see NCR 234 Qty 16</u>	<u>S/S</u> <u>07/10/02</u>	<u>[Signature]</u> <u>07/10/02</u>	<u>[Signature]</u> <u>05/10/02</u>	<u>[Signature]</u> <u>10/10/01</u>

NOTE: Date & initial all entries